

52036 - 602.041

Work Order ID 53207

October 26, 2009 1:01:19 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09/10/20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100

0.00



Large Fab

Large Fab

Memo 0.00
 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
 dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: *M109215*

PD 09.11.03

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

0.00

Quality Control

AD 09/11/06

Work Order ID 53207

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Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

$\Rightarrow S_{01}u/06$



QC

Quality Control

Memo

0.00

130

X PRESSURE - WASH
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to

$\Rightarrow M/ 02/11/09$

(X)

f

(X)

5

1ST COAT:

START TIME: 8:45 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:15 AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 4:30 PM

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:00 PM

Work Order ID 53207

Page 3

October 26, 2009 1:01:19 PM

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC3- Inspect Part Finish

0.00

JR

08/11/10

D.

QC



Quality Control

Memo

0.00

PRO 53187 PEG/11/11 0

150

IN STOCK.

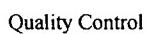
160/160



QC21- Final Inspection - Work Order Release

0.00

QC



Quality Control

Memo

0.00

09/11/11 HJ

MF
09-11-11

Picklist Print

Page 1

October 26, 2009 1:01:26 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	13.0000	1.0000			

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 1

48101 1

Main Warehouse

WA 12

51872 12

PD 09.11.02

D2221-5RevH Manufactured No 100 Each 2.0000 2.0000

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 2

50026 2

53151X2 PD 09.11.02

D2221-7RevH Manufactured No 100 Each 5.0000 1.0000

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA 5

51090 1

51251 4

PD 09.11.02

Picklist Print

Page 2

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	13.0000	2.0000			

Basket Hinge

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

13

50024

2

51870

11

ID 09.11.03

D2235-1RevB1



Manufactured

No

100

Each

20.0000

2.0000



Basket Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

7

51438

7

Main Warehouse

WA

13

50565

3

51871

10

ID 09.11.02

Picklist Print

Page 3

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	66.0000	2.0000			

Mounting Bracket

Warehouse

Location

Main Warehouse

ST	13
46086	2
48428	1
51120	10

Main Warehouse

WA	53
50872	4
51745	49

D3442-1RevA

Manufactured No

100 Each 18.0000 2.0000



Shim

Warehouse

Location

Main Warehouse

ST	1
46767	1

Main Warehouse

WA	17
50951	17

② CPC 09.11.04

PD 09.11.03

Picklist Print

Page 4

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Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Item ID/ Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured		No		100	Each	8.0000	2.0000			

Rib Assembly (Basket End)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	6	
51869	6	PD 09.11.02

Main Warehouse

WA	2	
51171	2	

D3826-041RevB



Manufactured

No

100 Each 8.0000 2.0000



Rib / Gusset Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	6	
51340	6	PD 09.11.02

Main Warehouse

WA	2	
51088	2	

Picklist Print

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October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	5.0000	1.0000			

Rib Assembly (Inboard)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	5	
51339	5	

RD 09.11.02

D3832-1RevA

Manufactured No

100 Each 6.0000 1.0000



Mesh (Base)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	2	
46306	1	
46774	1	

Main Warehouse

WA	4	
50942	1	
51863	3	

RD 09.11.03

Picklist Print

Page 6

October 26, 2009 1:01:27 PM

Work Order ID: 53207



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-1RevA		Manufactured	No			100	Each	10.0000	2.0000			

Mesh (Base End Face)



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse ST	8	
	8	AD 09.11.03
Main Warehouse WA	2	
	2	

8

7

6

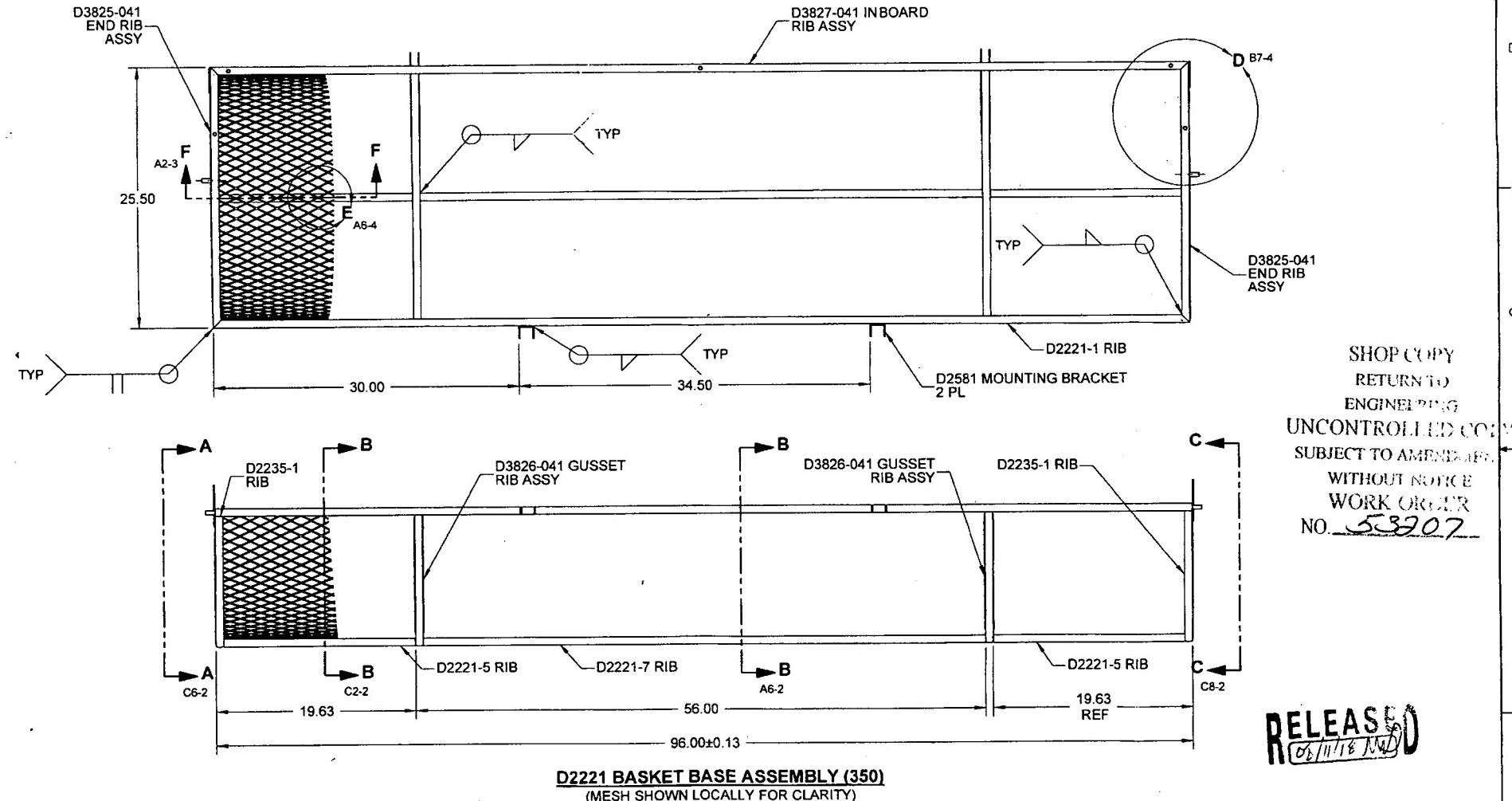
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	
MFG. APPR.		REV. H SHEET 2 OF 5	
APPROVED		TITLE BASKET BASE ASSEMBLY (350) NTS	
DE APPR.		SCALE	
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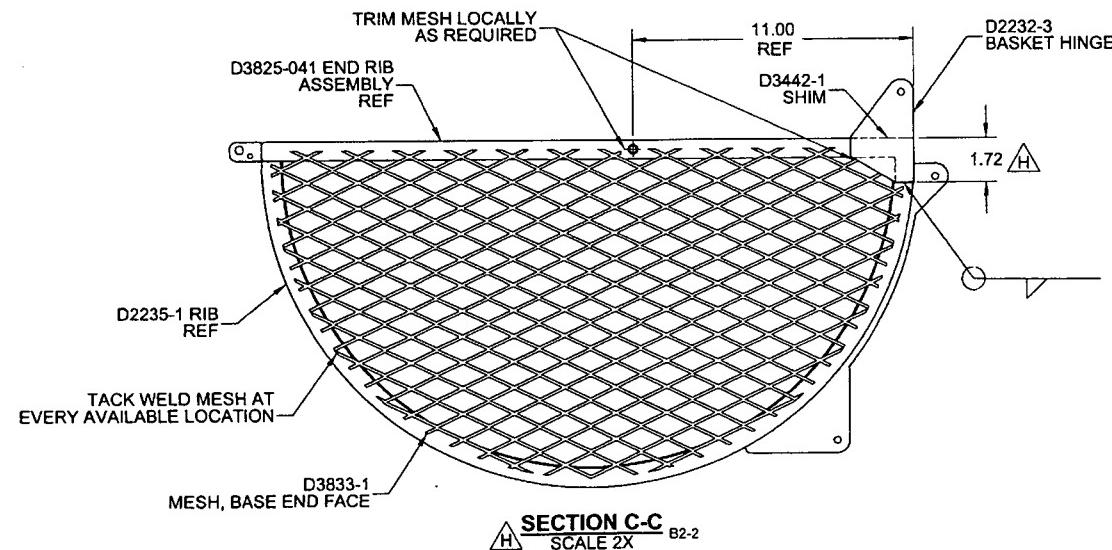
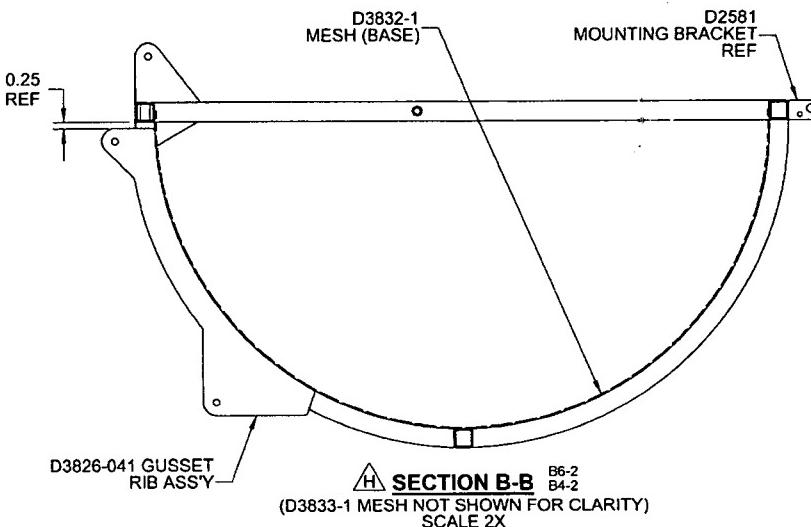
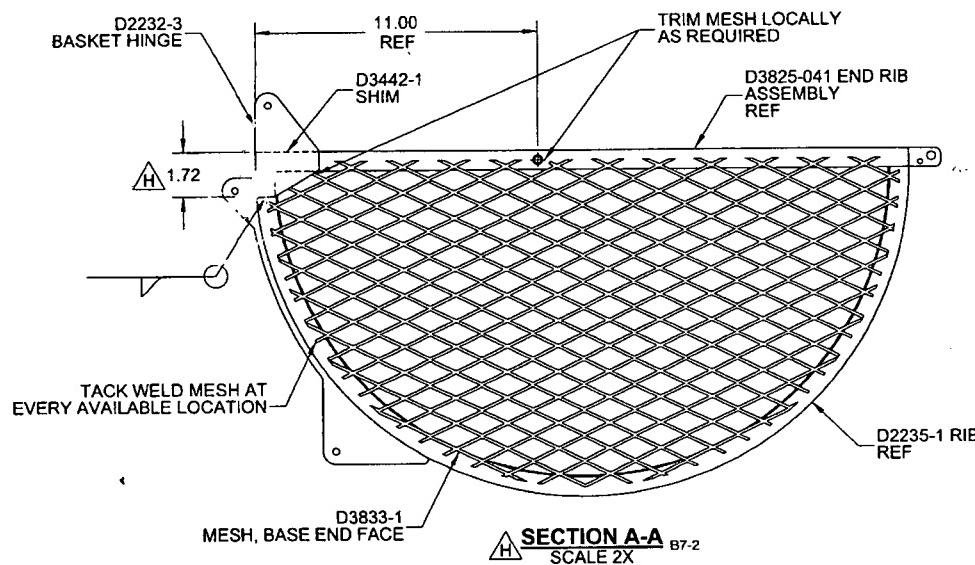
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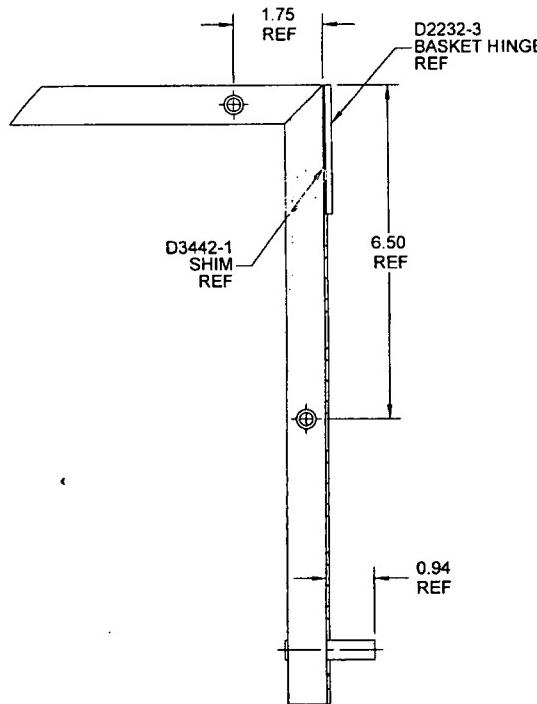


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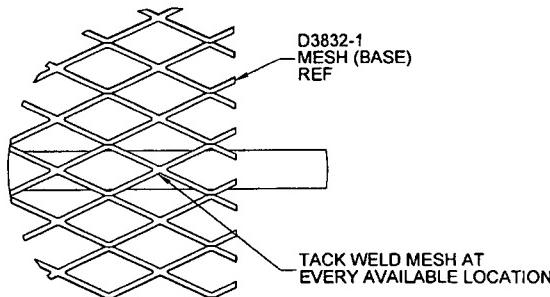
RELEASE
05/11/16

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DRAWN	<u>A</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>AS</u>	DRAWING NO. D2221 REV. H
MFG. APPR.	<u>M</u>	SHEET 3 OF 5
APPROVED	<u>M</u>	TITLE SCALE BASKET BASE ASSEMBLY (350) NTS
DE APPR.	<u>M</u>	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD
DATE	08.09.18	

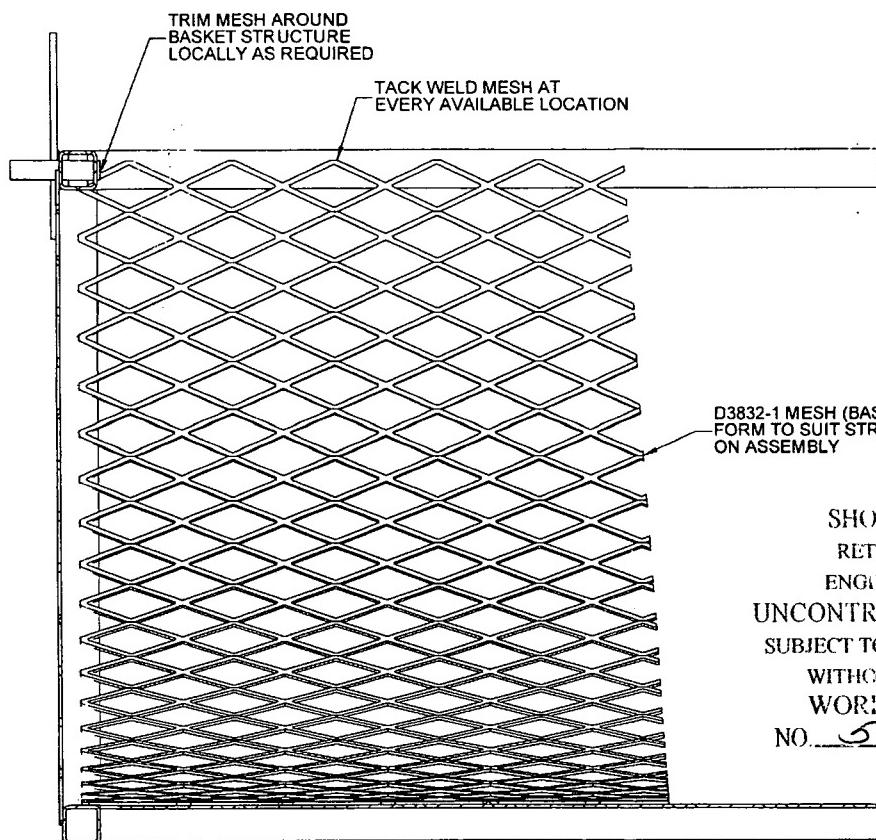
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DETAIL D D2-2
SCALE 4X



DETAIL E C6-2
SCALE 4X



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CHECKED	<u>AS</u>	DRAWING NO.	REV. H
MFG. APPR.	<u>AS</u>	D2221	SHEET 4 OF 5
APPROVED	<u>AS</u>	TITLE	SCALE
DE APPR.	<u>AS</u>	BASKET BASE ASSEMBLY (350) NTS	
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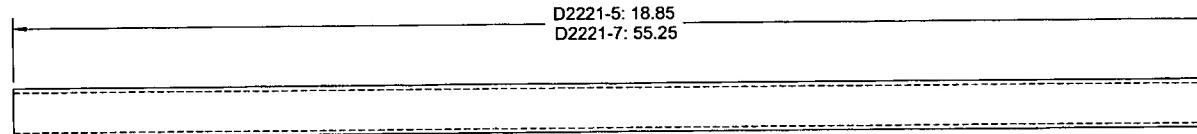
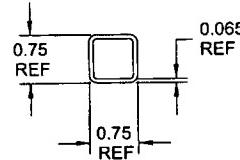
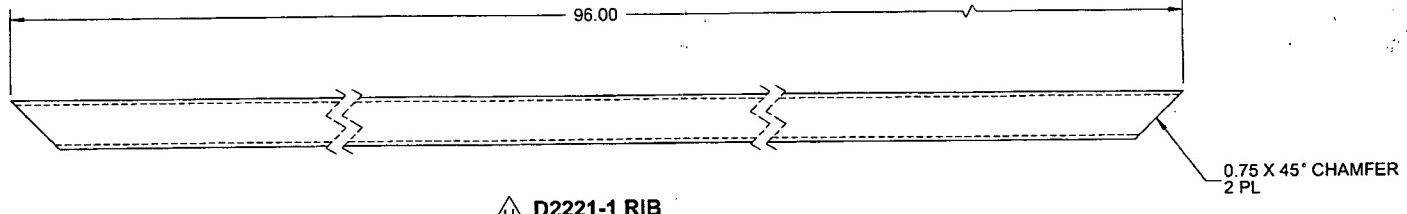
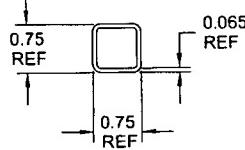
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D2221-5/-7 RIB

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WORK ORDER

NO. 58207

RELEASED
08/11/18/W

OTES:

-) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
-) FINISH: NONE
-) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
-) UNITS: INCHES UNLESS OTHERWISE NOTED
-) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
-) IDENTIFICATION: N/A
-) WEIGHT:D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

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DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>ADS</i>	DRAWING NO. REV. H
MFG. APPR.	<i>ADS</i>	D2221 SHEET 5 OF 5
APPROVED	<i>ADS</i>	TITLE SCALE
DE APPR.	<i>ADS</i>	BASKET BASE ASSEMBLY (350) NTS
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